



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D205-633-011
Job Sheet 184655



Part No: D205-633-011

Job Qty: 2 ea

Part Name: Heli-Access-Step™ - High Gear, Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/15/18

Job Tracking No:

Due Date: 11/8/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEET 17 IPP Rev:F 02.07.11 Reformat; Removed D3010 RF

Ship Via:

6006

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	11/8/18	11/8/18	0.00	0.00	Start Up Stores/Pkg-1	4.60	OCT 19 2018
110	Packaging	2 pcs	11/8/18	11/8/18	0.00	0.00	Packaging1-2	6.60	OCT 19 2018
120	QC	2 pcs	11/8/18	11/8/18	0.00	0.00	QC4	BB	OCT 22 2018
130	Packaging	2 pcs	11/8/18	11/8/18	0.00	0.00	Packaging3-1	BB	OCT 22 2018
135	DC	2 pcs	11/8/18	11/8/18	0.00	0.00	DC	29-89	OCT 22 2018
140	QC21-FG	2 Ea	11/8/18	11/8/18	0.00	0.00	QC21	21	OCT 22 2018

Part Op 130 - Identify and pack for shipping as per PPP D205-633-011 Location:FG082
Descriptions: 135 - Photocopy bluefile & type labels per PPP205-633-011 CHG001

9-88

Fy082

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-14A	Bolt	2 Ea (1 ea)	90-Start up Operation	5094583
AN4-5A	Bolt	4 Ea (2 ea)	90-Start up Operation	5089310
AN4-6A	Bolt	4 Ea (2 ea)	90-Start up Operation	5089455
AN4-7A	Bolt	4 Ea (2 ea)	90-Start up Operation	5057520
AN5-14A	Bolt	2 Ea (1 ea)	90-Start up Operation	5056344
AN5-6A	Bolt	2 Ea (1 ea)	90-Start up Operation	5103257
D2021-101	Eyebolt	2 Ea (1 ea)	90-Start up Operation	5091969
D2022-101	Spacer	4 Ea (2 ea)	90-Start up Operation	5106682
D2022-103	Spacer	4 Ea (2 ea)	90-Start up Operation	51047876
D2562-001	Strut 19.68"	2 Ea (1 ea)	90-Start up Operation	5112748
D2565-101	Strut	2 Ea (1 ea)	90-Start up Operation	5112883
D2565-103	Strut	2 Ea (1 ea)	90-Start up Operation	5111101
D2565-105	Strut	2 Ea (1 ea)	90-Start up Operation	5111119
D2565-107	Strut	2 Ea (1 ea)	90-Start up Operation	5111173
D2565-109	Strut	2 Ea (1 ea)	90-Start up Operation	5111283
D2565-111	Strut	2 Ea (1 ea)	90-Start up Operation	5111292
MS21042L4	Nut	16 Ea (8 ea)	90-Start up Operation	5094593
MS21042L5	Nut	4 Ea (2 ea)	90-Start up Operation	5083521
NAS1149D0463J	Washer	30 Ea (15 ea)	90-Start up Operation	5092780
NAS1149D0563J	Washer	8 Ea (4 ea)	90-Start up Operation	5093773
D2563	Step Weldment Assembly	2 Ea (1 ea)	110-Packaging	5114028

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																						
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																							
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																							
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																							
Large Fab ☐	Composite ☐	Supplier ☐																																																								
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval _____																																																						
Description Work Order Deviation		Disposition																																																								
Root Cause <table style="width:100%; border: none;"> <tr><td style="border: none;">Environment ☐</td><td style="border: none;">No Re-verification ☐</td></tr> <tr><td style="border: none;">Design ☐</td><td style="border: none;">Operator ☐</td></tr> <tr><td style="border: none;">Doc/Data ☐</td><td style="border: none;">Offset/Setup ☐</td></tr> <tr><td style="border: none;">Equip/Tooling ☐</td><td style="border: none;">Supplier ☐</td></tr> <tr><td style="border: none;">Handling/Pre ☐</td><td style="border: none;">Training ☐</td></tr> <tr><td style="border: none;">Material ☐</td><td style="border: none;">Use for Testing ☐</td></tr> <tr><td style="border: none;">Internal Transport ☐</td><td style="border: none;">Poor Information ☐</td></tr> <tr><td style="border: none;">Tribal Knowledge ☐</td><td style="border: none;">Rushing ☐</td></tr> <tr><td style="border: none;">LOA ☐</td><td style="border: none;">Product Improvement ☐</td></tr> <tr><td style="border: none;">Substation ☐</td><td style="border: none;">Process Improvement ☐</td></tr> <tr><td style="border: none;">Past Expiry Date ☐</td><td style="border: none;">Manufacturing Process ☐</td></tr> <tr><td style="border: none;">Misidentified ☐</td><td style="border: none;">Past Due ☐</td></tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	FAULT CATEGORY <table style="width:100%; border: none;"> <tr><td style="border: none;">Pressure/Forced ☐</td><td style="border: none;">Temperature/Cure ☐</td><td style="border: none;">Power ☐</td></tr> <tr><td style="border: none;">Bending ☐</td><td style="border: none;">Set-up ☐</td><td style="border: none;">Folio ☐</td></tr> <tr><td style="border: none;">Centre Not Concentric ☐</td><td style="border: none;">BOM/Route ☐</td><td style="border: none;">Grain ☐</td></tr> <tr><td style="border: none;">Cracks ☐</td><td style="border: none;">Broken/Damage/Defect ☐</td><td style="border: none;">Weld ☐</td></tr> <tr><td style="border: none;">Crimp/Kink/Ripple/Wave ☐</td><td style="border: none;">Inspection Incomplete/Unqualified ☐</td><td style="border: none;">Wroi ☐</td></tr> <tr><td style="border: none;">Cuffs ☐</td><td style="border: none;">Contamination ☐</td><td style="border: none;">Out of Sequence ☐</td></tr> <tr><td style="border: none;">Crushing ☐</td><td style="border: none;">Countersink ☐</td><td style="border: none;">Off-set ☐</td></tr> <tr><td style="border: none;">Heat Treat ☐</td><td style="border: none;">Cut Too Short ☐</td><td style="border: none;">Mislabeled ☐</td></tr> <tr><td style="border: none;">Wave/Twist in Tube ☐</td><td style="border: none;">Instructions Incomplete/Unclear ☐</td><td style="border: none;">Fit/Function ☐</td></tr> <tr><td style="border: none;">Marks/Chatter ☐</td><td style="border: none;">Drill Holes ☐</td><td style="border: none;">Misaligned/off center ☐</td></tr> </table>			Pressure/Forced ☐	Temperature/Cure ☐	Power ☐	Bending ☐	Set-up ☐	Folio ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wroi ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Crushing ☐	Countersink ☐	Off-set ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐
Environment ☐	No Re-verification ☐																																																									
Design ☐	Operator ☐																																																									
Doc/Data ☐	Offset/Setup ☐																																																									
Equip/Tooling ☐	Supplier ☐																																																									
Handling/Pre ☐	Training ☐																																																									
Material ☐	Use for Testing ☐																																																									
Internal Transport ☐	Poor Information ☐																																																									
Tribal Knowledge ☐	Rushing ☐																																																									
LOA ☐	Product Improvement ☐																																																									
Substation ☐	Process Improvement ☐																																																									
Past Expiry Date ☐	Manufacturing Process ☐																																																									
Misidentified ☐	Past Due ☐																																																									
Pressure/Forced ☐	Temperature/Cure ☐	Power ☐																																																								
Bending ☐	Set-up ☐	Folio ☐																																																								
Centre Not Concentric ☐	BOM/Route ☐	Grain ☐																																																								
Cracks ☐	Broken/Damage/Defect ☐	Weld ☐																																																								
Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wroi ☐																																																								
Cuffs ☐	Contamination ☐	Out of Sequence ☐																																																								
Crushing ☐	Countersink ☐	Off-set ☐																																																								
Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐																																																								
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐																																																								
Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐																																																								
OTHER : _____		By _____ ervisor _____ ation _____ nator _____ ong _____ isions _____ lerance _____ ng _____ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																																																								

DART AEROSPACE

Container No: S119915

Part: D205 - 638 - 011

Job No: 184655

Serial No/Batch: S119915

Revision: _____

Inspector: _____

Exp Date: _____

Instructions: TC STC SH96 - 57 Issue 5

Dart Aerospace Ltd.
1270 Aberdeen Street
Hemel Hempstead, HX 6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-14A	2	1,339	0
	AN4-5A	4	190	0
	AN4-6A	4	1,038	0
	AN4-7A	4	214	0
	AN5-14A	2	55	0
	AN5-6A	2	92	0
	D2021-101	2	22	0
	D2022-101	4	11	0
	D2022-103	4	13	0
	D2562-001	2	7	0
	D2565-101	2	5	0
	D2565-103	2	5	0
	D2565-105	2	5	0
	D2565-107	2	7	0
	D2565-109	2	5	0
	D2565-111	2	6	0
	MS21042L4	16	4,182	0
	MS21042L5	4	673	0
	NAS1149D0463J	30	5,123	0
	NAS1149D0563J	8	1,310	0
110-Packaging	D2563	2	2	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

5.0 PARTS LISTS

5.1 D205-633-011/-013/-015/-017 Heli-Access Step

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				D205-633-011	Heli-Access-Step™, High Gear
	X			D205-633-013	Heli-Access-Step™, Extended High Gear (31")
		X		D205-633-015	Heli-Access-Step™, Extended High Gear (39")
			X	D205-633-017	Heli-Access-Step™, Standard Low Gear
1			1	D2021-101	EYEBOLT
2	2	2	2	D2022-101	SPACER
2	2	2	2	D2022-103	SPACER
1				D2562-001	STRUT
		1		D2562-005	STRUT
			1	D2562-007	STRUT
	1			D2562-013	STRUT
1	1	1	1	D2563	WELDMENT ASSEMBLY
1				D2565-101	STRUT
1				D2565-103	STRUT
1				D2565-105	STRUT
1				D2565-107	STRUT
1				D2565-109	STRUT
1				D2565-111	STRUT
	1			D2565-201	STRUT
	1			D2565-203	STRUT
	1			D2565-205	STRUT
	1			D2565-207	STRUT
	1			D2565-209	STRUT
	1			D2565-211	STRUT
		1		D2565-301	STRUT
		1		D2565-303	STRUT
		1		D2565-305	STRUT
		1		D2565-307	STRUT
		1		D2565-309	STRUT
			1	D2565-401	STRUT
			1	D2565-403	STRUT
			1	D2565-405	STRUT
			1	D2565-407	STRUT
			1	D2565-409	STRUT
			1	D2565-411	STRUT
		1		D3165-1	SUPPORT ARM
	1	1		AN44-7A	EYEBOLT
2	1	1	2	AN4-5A	BOLT
2	3	3	2	AN4-6A	BOLT
2	2	2	2	AN4-7A	BOLT
1	1	1	1	AN4-14A	BOLT
	1	1		AN4-10A	BOLT
1			1	AN5-6A	BOLT
1	1	1	1	AN5-14A	BOLT
15	16	16	15	AN960JD416	WASHER
4	3	3	4	AN960JD516	WASHER
8	8	8	8	MS21042L4	NUT (or MS21042-4)
2	2	2	2	MS21042L5	NUT (or MS21042-5)

• COPYRIGHT © 2002 BY DART AEROSPACE LTD. •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: C

Date: 13.12.13

Change Record

PAGE 1 OF 1

Part Number: D205-633-011/-017

Description: HELI-ACCESS STEP; HIGH GEAR / STANDARD LOW GEAR

[illegible]